

Work Order ID 54328-2 *split*

December 8, 2009 8:44:47 AM



Page 1

Item ID: D3782-045

Accept



Setup Start



Revision ID:

Item Name: Back Leg Assembly

*22*  
*25*

Stop



Start Date: 08/12/2009 Start Qty: ~~40.00~~

Required Date: 16/12/2009 Req'd Qty: 40.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *PL*

Date: *09-12-8*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3782

Rev A

100

Pick Kit

0.00



Packaging

Memo

0.00

*SAD*  
*10-01-13*

*22*

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

*SAD*  
*10-01-13*

*22*

Small Fab

1-assemble as per dwg D3782

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

*SB 10/01/13*

*22*

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 54328

December 8, 2009 8:44:47 AM



Page 2

Item ID: D3782-045  
 Revision ID:  
 Item Name: Back Leg Assembly  
 Start Date: 08/12/2009 Start Qty: 40.00  
 Required Date: 16/12/2009 Req'd Qty: 40.00  
 Reference:

Accept



Setup Start



Stop



Cust Item ID:  
 Customer:



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location: <u>254</u>  Memo	0.00  0.00							
140  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							

*14/12/09* (22)

*10/01/15*

*MF*  
*10-1-14*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

December 8, 2009 8:44:52 AM

Page 1

Work Order ID: 54328

Parent Item: D3782-045

Parent Item Name: Back Leg Assembly

Start Date: 08/12/2009

Required Date: 16/12/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-15A Purchased

No

110

Each

182.0000

80.0000



Bolt

SAD 10-01-12

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

113121

182

182

110

Each

67.0000

40.0000

AN45-15A

Purchased

No



EYE BOLT

8

SAD 10-01-12

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

107938

109012

109091

109118

67

4

33

12

18

20

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

December 8, 2009 8:44:52 AM

Page 2

Work Order ID: 54328

Parent Item: D3782-045

Parent Item Name: Back Leg Assembly


Comments:

Start Date: 08/12/2009

Required Date: 16/12/2009

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN5-15A  Bolt		Purchased	No			110	Each	95.0000	40.0000			

SAD 10-01-12

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	95	
108880	7	
110153	1	
111668 ✓	85	
14115	2	

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
22  
\_\_\_\_\_

AN5-17A



Bolt

Purchased

No

110

Each

56.0000

40.0000

SAD 10-01-12

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	56	
102140	4	
107939	2	
110625	2	
112314	1	
112385 ✓	47	

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
22  
\_\_\_\_\_

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Shop Packet Print

Page 2



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 3

December 8, 2009 8:44:52 AM

Work Order ID: 54328

Parent Item: D3782-045

Parent Item Name: Back Leg Assembly

Comments:

Start Date: 08/12/2009

Required Date: 16/12/2009

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD416

Purchased

No

110

Each

2,177.000

160.0000



Washer



SAD 10-01-12

✓ NAS114800463J  
QST 4.2.11

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2177

108161

329

110523

340

111279

101

111916

482

112314

925

16941

0

AN960JD516

Purchased

No

110

Each

976.0000

200.0000



Washer



SAD 10-01-12

NAS1149D0563J

✱ (QST 017  
4.2.11)

✱ SEE W/D  
CHG, OVER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

976

110363

46

110523

57

111279

39

112082

64

112314

14

112828

256

113149 ✓

500

M113288

112 x = 60

(10) x 5 = 50

December 8, 2009 8:44:52 AM

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.01.12		ON DWG D3782 Rev A SHEET 4, THE NAS11490568J SHOULD SAY NAS11490563J. TYPO.	SAD	10-01-12	10	CP 10.01.12 PCL QSI 1412	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Page 4

Work Order ID: 54328

Parent Item: D3782-045

Parent Item Name: Back Leg Assembly

Start Date: 08/12/2009

Required Date: 16/12/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3764-1		Manufactured	No			110	Each	16.0000	40.0000			
												
Back Leg Fitting												

SAD 10-01-12

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	16	
40970	2	
42958	6	
51397	8	

D3772-1		Manufactured	No			110	Each	6.0000	40.0000			
												
Back Leg												

SAD 10-01-12

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	6	
42240	2	
42964	4	

D3773-041		Manufactured	No			110	Each	0.0000	40.0000			
												
Headrest Assembly												

SAD 10-01-12

B54442 x2  
B54342 x20



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 5

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Work Order ID: 54328

Parent Item: D3782-045

Parent Item Name: Back Leg Assembly

Comments:


Start Date: 08/12/2009

Required Date: 16/12/2009


Start Qty: 40.00

Required Qty: 40.00

Component Item: (D)/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3786-1		Manufactured	No			110	Each	29.0000	40.0000			
												
Sleeve												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse	354376	920
ST	29	
43036	18	
44533	11	3

D3787-1		Manufactured	No			110	Each	36.0000	40.0000			
												
Foot												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse	54337	
ST	36	
39397	3	
46597	33	

MS21042L4		Purchased	No			110	Each	4,055.000	80.0000			
												
Nut												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	4055	
110507	184	
111827	3871	
15924	0	

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 6

December 8, 2009 8:44:52 AM

Work Order ID: 54328



Parent Item: D3782-045



Parent Item Name: Back Leg Assembly

Start Date: 08/12/2009

Required Date: 16/12/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MS21042L5

Purchased

No

110

Each

730.0000

120.0000



SAW 10-01-12

Nut

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

730

110382

10

111636

11

112314

709

66

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

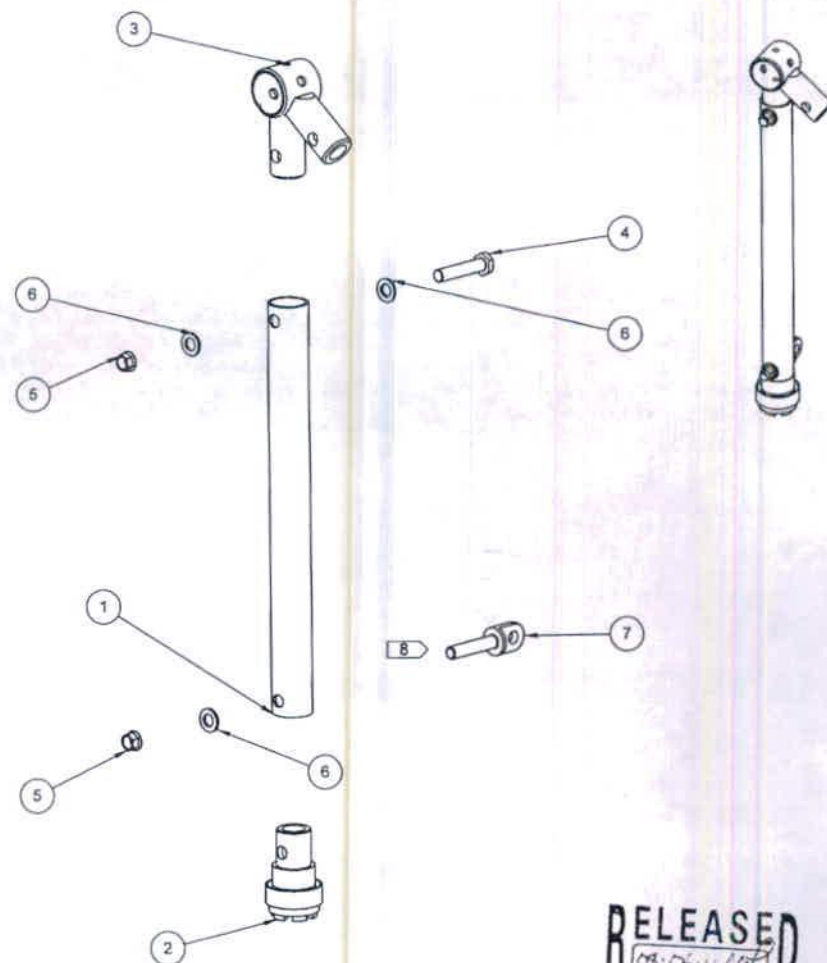
ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3768-1	FRONT INBOARD LEG	1
2	D3787-1	FOOT	1
3	D3762-041	FRONT LEG FITTING ASSY	1
4	AN5-13A	BOLT	1
5	MS21042L5	NUT	2
6	NAS1149D0568J	WASHER (AN960JD516)	3
7	AN45-13A	EYE BOLT	1

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 54328  
 BP 09-12-8

# **D3782-041 FRONT INBOARD LEG ASSEMBLY**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs
- 8) ITEM 5 (AN45-13A EYE BOLT) INSTALLED AS SHOWN FOR D412-769-041 AFT FACING SEAT, LH  
INSTALLED IN REVERSE FOR D412-769-042 AFT FACING SEAT, RH



RELEASED  
 08-06-04

A	NEW ISSUE			HS	08.06.04
REV.	DESCRIPTION			BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			REV. A
DRAWN	HS				
CHECKED		DRAWING NO.	SHEET 1 OF 4		
MFG. APPR.		D3782	SCALE		
APPROVED		TITLE	NTS		
DE APPR.		LEG ASSEMBLY			
DATE	08.06.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD			
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3768-3	FRONT OUTBOARD LEG, LH	1
2	D3787-1	FOOT	1
3	D3762-041	FRONT LEG FITTING ASSY	1
4	AN45-13A	EYE BOLT	2
5	MS21042L5	NUT	2
6	NAS1149D0568J	WASHER (AN960JD516)	2

# D3782-043 FRONT OUTBOARD LEG ASSY, LH

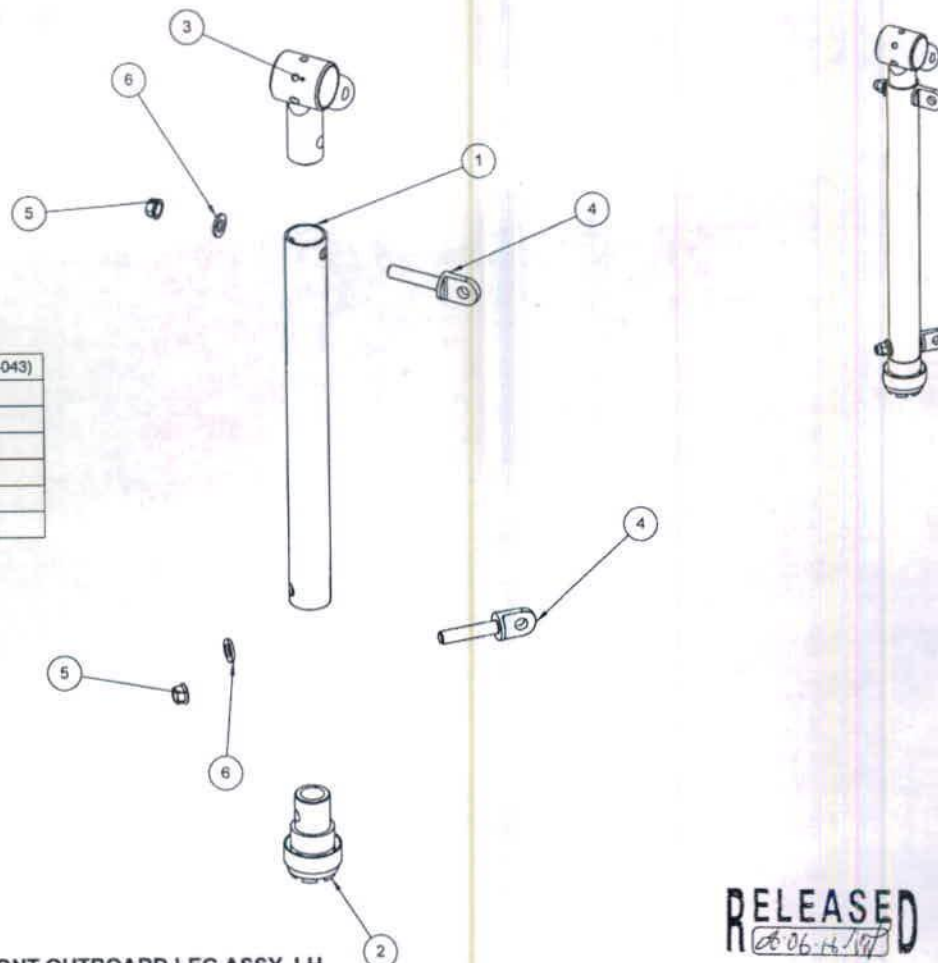
## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	HS	
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D3782 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		LEG ASSEMBLY NTS
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08.06.04

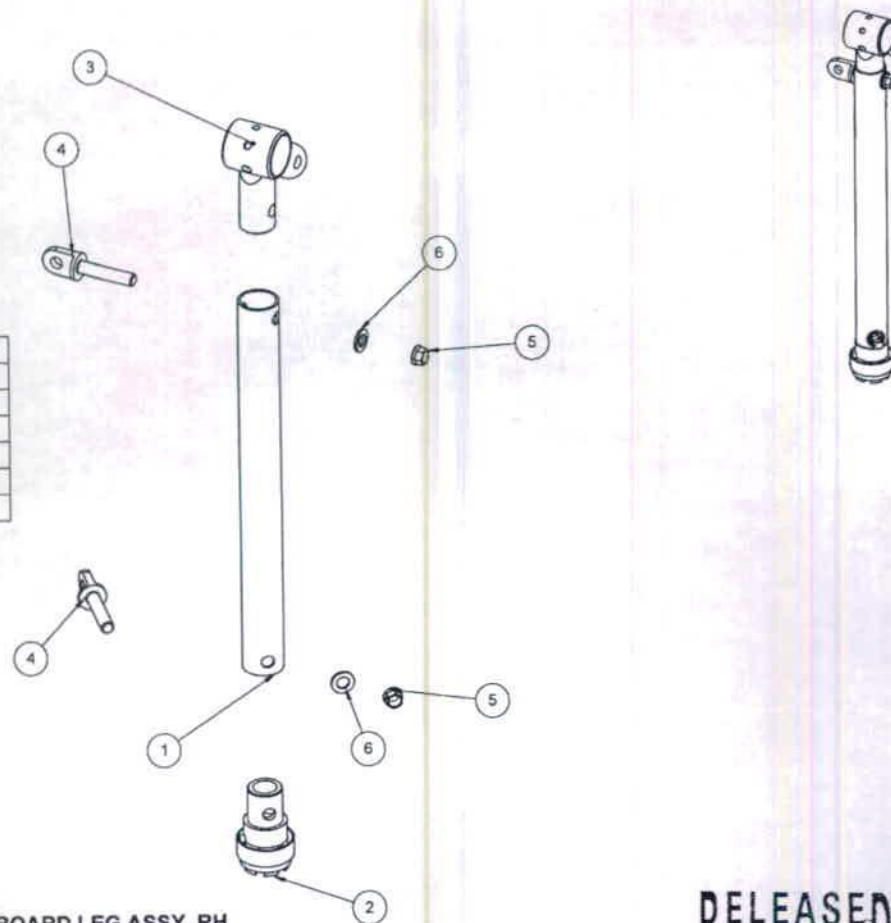
W/0 54328







ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3768-4	FRONT OUTBOARD LEG, RH	1
2	D3787-1	FOOT	1
3	D3762-041	FRONT LEG FITTING ASSY	1
4	AN45-13A	EYE BOLT	2
5	MS21042L5	NUT	2
6	NAS1149D0568J	WASHER (AN960JD516)	2



**D3782-044 FRONT OUTBOARD LEG ASSY, RH**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

**RELEASED**  
03.06.14

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWN	HS		
CHECKED		DRAWING NO.	SHEET 3 OF 4
MFG. APPR.		D3782	
APPROVED		TITLE	SCALE
DE APPR.		LEG ASSEMBLY	NTS
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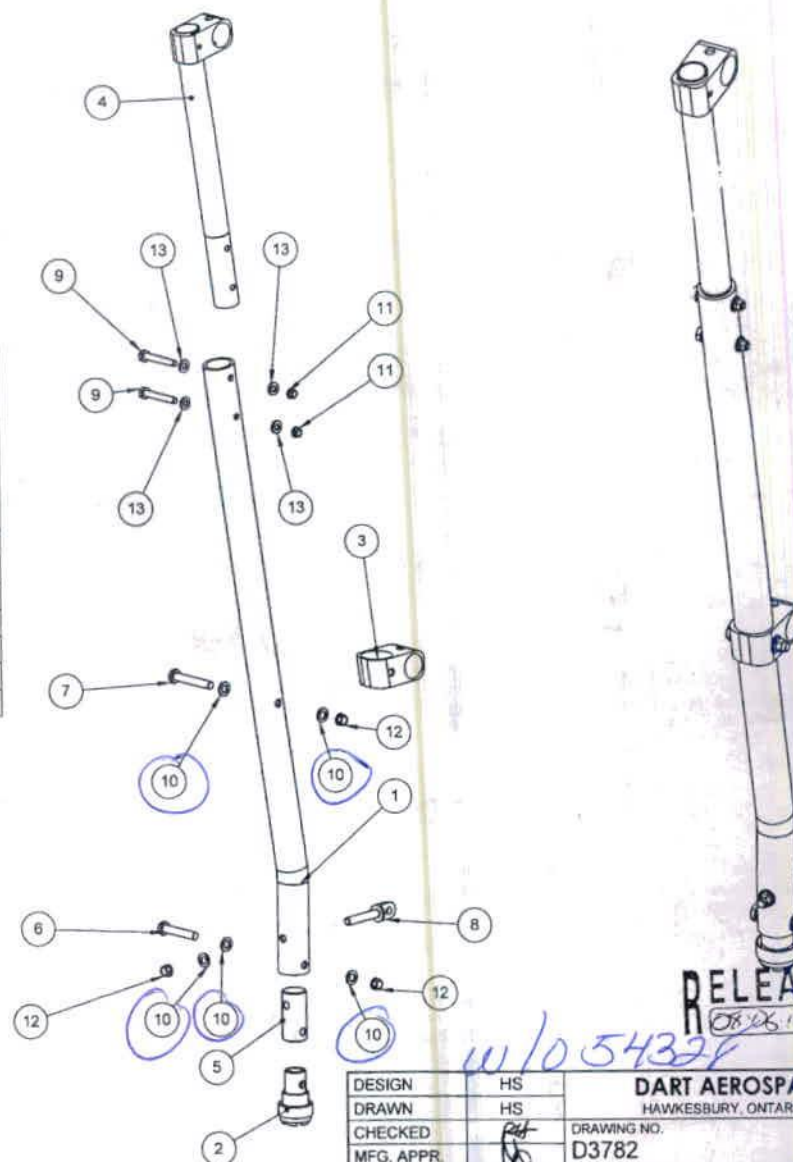


ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3772-1	BACK LEG	1
2	D3787-1	FOOT	1
3	D3764-1	BACK LEG FITTING	1
4	D3773-041	HEAD REST ADAPTER ASSY	1
5	D3788-1	SLEEVE	1
6	AN5-15A	BOLT	1
7	AN5-17A	BOLT	1
8	AN45-15A	EYE BOLT	1
9	AN4-15A	BOLT	2
10	NAS1149D0568J	WASHER (AN960JD516)	5
11	MS21042L4	NUT	2
12	MS21042L5	NUT	3
13	NAS1149D0463J	WASHER (AN960JD416)	4

# **D3782-045 BACK LEG ASSY**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.71 lbs



DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3782</b> TITLE <b>LEG ASSEMBLY</b> SCALE <b>NTS</b>
DRAWN	HS	
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	08.06.04	REV. A SHEET 4 OF 4 COPYRIGHT © 2008 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**RELEASED**  
08/06/15

W/05432



